

Wednesday, July 06, 2011 1:20:46 PM

Page 1

**Accept**

**Setup    Start**

**Stop**

**Cust Item ID:**

**Customer:**

**Reference:**

Run Start

**Stop**

QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

**Insp.  
Stamp**

Revision Nbr

D2278

Rev F

100

0.00

**Abstract**

## FLOW WATER JET

## Waterjet

## Memo

0.00

FLOW CNC Waterjet

1-Cut as per Dwg D2278    ☐ Dwg Rev: F    ☐ Prog Rev: F    ☐ 2-  
Deburr if necessary

6561 . 68)

110

QC2- Inspect parts off machine FAI/FAIB

0.00

[illegible]

## Memo

0.00

QC

## Quality Control

120

QC8- Inspect parts - second check

0.00

\_\_\_\_\_

## Memo

0.00

QC

## Quality Control

**Dart Aerospace Ltd**

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

# Work Order ID 71576

Wednesday, July 06, 2011 1:20:46 PM



Page 2

Item ID: D2278

Accept



Setup Start



Revision ID:

Item Name: Step Leg

Stop



Start Date: 7/6/2011 Start Qty: 10.00



Cust Item ID:

Required Date: 7/20/2011 Req'd Qty: 10.00



Customer:

Reference:

Approvals:

Process Plan: \_\_\_\_\_

Date: \_\_\_\_\_

Tooling: \_\_\_\_\_

Date: \_\_\_\_\_

Run Start



QC: \_\_\_\_\_

Date: \_\_\_\_\_

SPC (Y/N): \_\_\_\_\_

Date: \_\_\_\_\_

Stop



Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Tool ID

Tool #

Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

130

Chemical Conversion Coat per QSI005 4.1

0.00



HandFinish

Memo

0.00

Hand Finishing

X10  $\phi$  Illuloz110

140

QC3- Inspect Part Finish

0.00



QC

Memo

0.00

Quality Control

10 BL 11-7-18

150

Identify as per dwg & Stock Location: 6A

0.00



Packaging

Memo

0.00

Packaging

ES 11/07/19 (10)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

**Work Order ID 71576**

Wednesday, July 06, 2011 1:20:46 PM

Page 3



Item ID: D2278

Accept



Setup Start



Revision ID:

Stop



Item Name: Step Leg

Start Date: 7/6/2011 Start Qty: 10.00



Cust Item ID:

Required Date: 7/20/2011 Req'd Qty: 10.00



Customer:

Reference:

Approvals:

Process Plan: \_\_\_\_\_

Date: \_\_\_\_\_

Tooling: \_\_\_\_\_

Date: \_\_\_\_\_

Run Start



QC: \_\_\_\_\_

Date: \_\_\_\_\_

SPC (Y/N): \_\_\_\_\_

Date: \_\_\_\_\_

Stop

Sequence ID/  
Work Center IDOperation  
DescriptionSet Up/  
Run Hours

Tool ID

Tool #

Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

160

QC21 - Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

11/7/19 [Signature]  
ME  
11-07-19

# Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

# Picklist Print

Wednesday, July 06, 2011 1:20:44 PM

Page 1

Work Order ID: 71576



Parent Item: D2278



Parent Item Name: Step Leg

Start Date: 7/6/2011

Required Date: 7/20/2011

Start Qty: 10.00

Required Qty: 10.00

Comments: IPP Rev:A New Issue 05-11-07 JLM  
IPP Rev:B Now 6061-T6 06-06-23 JLM  
IPP Rev C New flat pattern 08.01.11 EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
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M6061T6S.080

Purchased

No

100

sf

230.9000

0.9815

10.33158



B11-7-14

6061-T6 .080 Sheet

Location

Loc Qty

Loc Code

MAT021

230.9

116268

17.5

117285

213.4

117285



W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

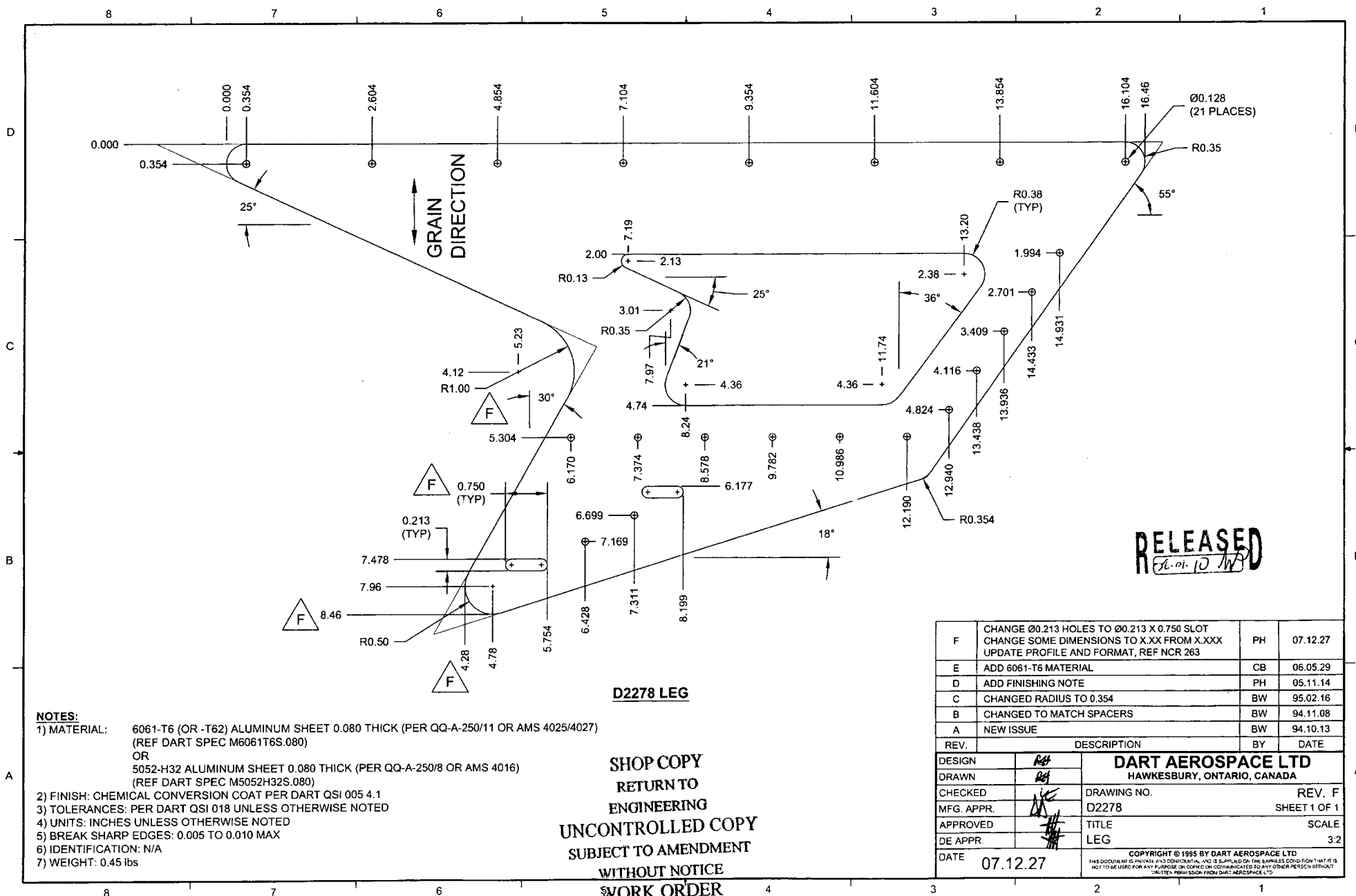
Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries







# **NOTES:**

- 1) MATERIAL: 6061-T6 (OR -T62) ALUMINUM SHEET 0.080 THICK (PER QQ-A-250/11 OR AMS 4025/4027) (REF DART SPEC M6061T6S.080) OR 5052-H32 ALUMINUM SHEET 0.080 THICK (PER QQ-A-250/8 OR AMS 4016) (REF DART SPEC M5052H32S.080)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.45 lbs

**SHOP COPY**  
**RETURN TO**  
**ENGINEERING**  
**UNCONTROLLED COPY**  
**SUBJECT TO AMENDMENT**  
**WITHOUT NOTICE**  
**WORK ORDER**  
**NO. 71576**

F	CHANGE Ø0.213 HOLES TO Ø0.213 X 0.750 SLOT CHANGE SOME DIMENSIONS TO X.XX FROM X.XXX UPDATE PROFILE AND FORMAT, REF NCR 263	PH	07.12.27
E	ADD 6061-T6 MATERIAL	CB	06.05.29
D	ADD FINISHING NOTE	PH	05.11.14
C	CHANGED RADIUS TO 0.354	BW	95.02.16
B	CHANGED TO MATCH SPACERS	BW	94.11.08
A	NEW ISSUE	BW	94.10.13
REV.	DESCRIPTION	BY	DATE
DESIGN	RA	<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA	
DRAWN	RA		
CHECKED	KE		
MFG. APPR.	KE		
APPROVED	KE		
DE APPR.	KE	DRAWING NO. D2278 REV. F SHEET 1 OF 1 TITLE LEG SCALE 3:2	
DATE	07.12.27	<small>COPYRIGHT © 1995 BY DART AEROSPACE LTD  THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL, AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.</small>	